

THE JACOBS MANUFACTURING COMPANY

Jacobs Plain Bearing Chucks



The Jacobs Plain Bearing Chuck is the most widely used chuck in the world today—standard equipment with the vast majority of portable tool makers here and abroad.

Unmatched for accuracy, strength, and gripping power, it is the ideal drill chuck. Furnished with both tapered and threaded back mounts.



Light Duty—For Tapered Arbors and Spindles

Chuck Model	Capacity	Price Each	Mount	Keys Each	Jaws & Nuts Per Set	Sleeves Each
0	0-1/32	\$6.96	0 JT	.37	\$3.21	\$1.07
1A	0-1/4	5.89	1 JT	.37	2.41	.96
2A	0-3/8	6.96	2 JT	.53	2.67	1.07
6AE	0-1/2	8.56	E JT	.59	3.48	1.50
6A-2A	0-1/2	8.56	2 JT	.59	3.48	1.50
6A-33	0-1/2	8.56	33 JT	.59	3.48	1.50
633C**	0-1/2	9.63	33 JT	.59	3.48	1.50
633D***	0-1/2	9.63	33 JT	.59	3.48	1.50
33	3/4-1/2	8.02	33 JT	.53	3.21	1.18
3326	3/4-1/2	8.02	3/4" St. Hole	.53	3.21	1.18
3333C**	3/4-1/2	9.09	33 JT	.53	3.21	1.18

Medium Duty—For Tapered Arbors and Spindles

Chuck Model	Capacity	Price Each	Mount	Keys Each	Jaws & Nuts Per Set	Sleeves Each
7	0-1/4	5.89	2 Short JT	.43	2.41	.96
7-1A	0-1/4	5.89	1 JT	.43	2.41	.96
30	0-3/8	6.42	2 Short JT	.48	2.67	.96
30-1A	0-3/8	6.42	1 JT	.48	2.67	.96
32	0-3/8	6.96	2 JT	.53	2.67	1.18
34	0-1/2	8.56	6 JT	.59	3.48	1.50
3	0-1 1/2	10.16	3 JT	.59	4.01	1.87
3A	1/4-3/8	10.16	3 JT	.59	4.01	1.87
3AE	1/4-3/8	10.16	E JT	.59	4.01	1.87
36	3/4-3/8	12.84	3 JT	.86	5.08	2.41
36E	3/4-3/8	12.84	E JT	.86	5.08	2.41

*Light Duty—For Threaded Spindles

Chuck Model	Capacity	Price Each	Thread	Chuck Model	Capacity	Price Each	Thread
0B 3/16-24	0-3/32	\$ 6.96	3/16-24	6B 1/2-20	0-1/2	\$8.56	1/2-20
1B 3/8-24	0-1/4	5.89	3/8-24	6B 1/2-24	0-1/2	8.56	1/2-24
1B 3/8-24	0-3/8	5.89	3/8-24	33B 3/8-24	3/4-1/2	8.02	3/4-24
1B 3/8-24	0-1/4	5.89	3/8-24	33B 1/2-20	3/4-1/2	8.02	1/2-20
2B 3/8-24	0-3/8	6.96	3/8-24	33B 3/8-16	3/4-1/2	8.02	3/4-16
6B 1/2-13	0-1/2	8.56	1/2-13				

Medium Duty—For Threaded Spindles

Chuck Model	Capacity	Price Each	Thread	Chuck Model	Capacity	Price Each	Thread
7B 3/8-24	0-1/4	5.89	3/8-24	34B 3/4-16	0-1/2	8.56	3/4-16
7B 1/2-20	0-1/4	5.89	1/2-20	34B 3/4-16	0-1/2	8.56	3/4-16
30B 3/8-24	0-3/8	6.42	3/8-24	36B 3/8-16	3/4-3/8	12.84	3/4-16
30B 1/2-20	0-3/8	6.42	1/2-20	36B 3/8-16	3/4-3/8	12.84	3/4-16
3B 3/8-16	1/4-3/8	10.16	3/8-16	32B 1/2-20	0-3/8	6.96	1/2-20
3B 3/8-11	1/4-3/8	10.16	3/8-11	32B 3/8-16	0-3/8	6.96	3/4-16
3B 3/4-16	1/4-3/8	10.16	3/4-16	32B 3/4-16	0-3/8	6.96	3/4-16
3B 3/4-16	1/4-3/8	10.16	3/4-16	34B 3/8-16	0-1/2	8.56	3/4-16

*Parts for B threaded chucks are interchangeable with the tapered models and carry the same list prices.

**Equipped with a threaded locking collar which has a 1 1/4 x 20 thread.

***Equipped with a threaded locking collar which has a 1 1/4 x 12 thread.



Jacobs Chuck Keys

Key No.	List Price	Fits Chucks
0	.37	No. 0, 0B
1	.37	No. 1, 1A, 1B, 1BB, 1BS
2	.53	No. 2, 2A, 2B, 2AD
3	.59	No. 3, 3A, 3B, 3AE, 6, 6A-2A, 6A-33, 6B, 6AE, 34, 34B, 14, 14N, 54B, 55B, 56B, 58B, 34VR, 75A
3C	.59	No. 633C, 633D
4	.86	No. 4, 16, 16N, 18, 18N, 36, 36B, 36E, 59B
5	1.44	No. 5, 20, 20N
7	.43	No. 7, 7B, 7-1A, 7D, 255, 7BB
7 H.D.	.54	No. 7, 7B, 7-1A
30	.48	No. 30, 30B, 30-1A, 30D, 8 1/2, 8 1/2N, 318, 30BB
32	.53	No. 32, 32B, 33, 33B, 9, 11, 11N, 381, 32BB, 33BB, 3326
32C	.53	No. 3333C

JT SIGNIFIES JACOBS TAPER

Jacobs Ball Bearing Super Chucks



The recently improved inserted ball thrust race and continuous deep groove, chrome nickel alloy jaws and heat treated alloy steel nut have made this chuck the world wide favorite for HEAVY DUTY drilling. Highly recommended if you desire the utmost from your drill press, lathe, or hand screw machine.



Model No.	Capacity, Incn	Price Each	Taper	Keys Each	Jaws & Nuts Per Set	Sleeves Each	Ball Thrust, Race & Balls Each
8 1/2 N	0-1/4	\$ 7.49	2 Short JT	.48	\$3.21	\$1.07	\$.64
11N	0-3/8	9.09	2 JT	.53	3.74	1.50	.80
14N	0-1/2	12.30	3 JT	.59	4.81	2.14	.96
16N	1/4-3/8	14.44	3 JT	.86	5.89	2.57	1.28
18N	1/4-3/8	20.33	4 JT	.86	7.49	3.74	1.61
20N	3/4-1	28.00	5 JT	1.44	10.16	5.35	2.41

Jacobs Arbors and Adapters

TAPER SHANK ARBORS

Shank Taper	0	1	2*	3	4	5	6	E	33
#0 Morse	\$1.10	—	—	\$1.10	—	—	—	—	\$1.10
#1 Morse	1.10	\$1.10	\$1.10	1.10	\$1.50	—	\$1.10	—	1.10
#2 Morse	1.10	1.10	1.10	1.10	1.50	\$3.00	1.10	\$1.10	1.10
#3 Morse	—	1.65	1.65	1.65	1.75	3.00	1.65	—	1.65
#4 Morse	—	2.65	2.65	2.65	2.65	3.00	2.65	—	2.65
#5 Morse	—	—	5.00	5.00	5.00	5.00	5.00	—	—
#7 Brown & Sharpe	—	—	2.50	2.50	—	—	2.50	—	—
#9 Brown & Sharpe	—	—	—	6.00	6.50	—	6.00	—	—
#10 Brown & Sharpe	—	—	—	7.25	7.25	—	—	—	—

STRAIGHT SHANK ARBORS

Shank Dia. and Length	0	1	2*	3	4	5	6	E	33
1/2"x2 1/2"	\$1.20	\$1.20	\$1.20	\$1.50	—	—	\$1.20	—	\$1.20
3/4"x2 1/2"	—	1.20	1.20	1.50	—	—	1.20	—	1.20
1"x3"	—	—	1.80	1.80	2.00	—	1.80	—	1.80
1 1/2"x3"	—	—	2.00	2.00	2.50	—	2.00	—	2.00
1 1/2"x4"	—	—	—	3.25	3.25	—	—	—	—
1 3/4"x4"	—	—	—	3.50	3.50	—	—	—	—

MOTOR SHAFT ADAPTERS

Motor Shaft Size	0	1	2*	3	4	5	6	E	33
1/2" Diam.	—	—	\$3.00	\$3.00	—	—	\$3.00	—	\$3.00

THREADED ARBORS

Shank Taper	Thread	Price
#2 Morse	3/8-24	\$4.50
#2 Morse	1/2-20	4.50
#2 Morse	3/4-16	4.50

NOTE: The above listing represents our standard arbors that are carried in stock. All arbors and motor shaft adapters not appearing on the above price list are special. Prices and delivery will be quoted upon application.

*No. 2 Jacobs Taper Arbors will be supplied for use with chucks having a #2 short Jacobs Taper Mounting hole.

Jacobs Single Purpose Chucks



Extensively used for high production work where tool sizes are rarely changed—drives all straight shank drills, taps, reamers, combination drills and countersinks, end mills, Woodruff key cutters, etc. Provided with either Morse Taper or Brown and Sharpe Taper Shanks.

For complete details, ask your Industrial Supply Distributor for the Jacobs Single Purpose Chuck catalog.



THE JACOBS MANUFACTURING COMPANY

Jacobs Headstock Chucks



This chuck mounted on the headstock and tailstock of a lathe facilitates accurate centering, drilling, reaming, counterboring, and tapping operations.

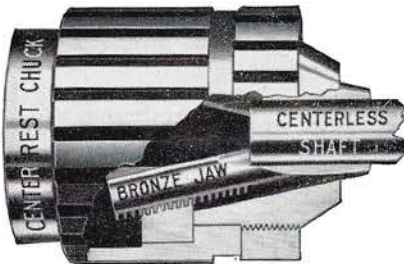
Made to thread directly to the spindles of small lathes. It is extremely accurate and convenient to use. The hollow construction

makes it possible to chuck long pieces extending in to the spindle of the lathe.

Chuck Model	Capacity	Price Each	Thread	Keys Each	Jaws & Nuts Per Set	Sleeves Each
55B 1-8	*0-17/32	\$14.18	1-8	\$.59	\$4.01	\$1.87
56B 1-10	*0-17/32	14.18	1-10	.59	4.01	1.87
58B 1 1/2-8	1/4-3/4	17.65	1 1/2-8	.59	4.01	1.87
59B 1 1/2-8	3/16-3/4	21.13	1 1/2-8	.86	5.08	2.41

*1/8 - 1/4 optional

Jacobs Center Rest Chucks



Mounted in the tailstock of the lathe by means of a solid taper arbor, which replaces the center. It permits an extremely accurate support for turning round work when a center cannot be used or the center hole is damaged. Stationary bronze jaws provide a bearing for the work that is being turned. These jaws are adjusted by means of

the sleeve, to the diameter of the work to be supported, and locked to size. This chuck replaces the lathe bed steady rest, is easier to use, and has equal accuracy. When combined with either the Jacobs Headstock Chuck, or the No. 75A Armature Driving Chuck, it makes ideal equipment for turning centerless pieces, such as Commutators on centerless shafts. The No. 75A Chuck is a medium duty key type Plain Bearing Chuck with a capacity of from 1/4-3/4". Length jaws closed, 3 3/4". Length jaws open, 2 13/16". Diameter, 2 5/8". Capacity, 1/4-3/4".

In ordering specify name and model number of lathe or hole specifications of spindle.

Chuck Model	Capacity	Price Each	Mount	Keys Each	Jaws & Nuts Per Set	Sleeves Each
75A	1/4-3/4	\$11.77	3JT	\$.59	\$4.01	\$1.87
100CR	1/4-3/4	12.50	3JT	None	4.01	1.87

Jacobs Rubber-Flex Tap Chucks



For the tapping head, tapping machine, drill press, automatic or hand screw machine. Can be attached either directly to the spindle or by means of a straight or tapered shank arbor.

Features include light weight, small diameter, precision ground construction, tremendous gripping power, and simplified tap changing.

Each collet takes all taps in its range requiring no individual sleeves or changing. Has hardened nickel molybdenum alloy steel jaws.

Price of chuck includes wrenches and hex key.



Chuck Model	Capacity	Price Each	Mount	Body Price Each	Nut Price Each	Collet Price Each	Back Jaw Unit	Nut Wrench Each	Body Wrench Each	Hex Key Each
400-01	0-10	\$10.16	1JT	\$5.35	\$1.77	\$2.78	\$1.50	\$.48	\$.48	\$.10
420-01	10-3/16	11.23	1JT	5.89	2.14	2.94	1.71	.91	.48	.10
420-02	10-3/16	11.23	2 Short JT	5.89	2.14	2.94	1.71	.91	.48	.10
421-01	0-1/4	11.23	1JT	5.89	2.14	2.94	1.71	.91	.48	.10
421-02	0-1/4	11.23	2 Short JT	5.89	2.14	2.94	1.71	.91	.48	.10
421-J8	0-1/4	11.23	3/4 Sq. Hole	5.89	2.14	2.94	1.71	.91	None	.10
440-02	3/16-3/4	12.84	2JT	6.96	2.41	3.10	1.87	.91	.91	.10
440-06	3/16-3/4	12.84	6JT	6.96	2.41	3.10	1.87	.91	.91	.10
440-J10	3/16-3/4	12.84	3/4 Sq. Hole	6.96	2.41	3.10	1.87	.91	None	.10
441-02	10-1/2	12.84	2JT	6.96	2.41	3.10	1.87	.91	.91	.10
441-06	10-1/2	12.84	6JT	6.96	2.41	3.10	1.87	.91	.91	.10
441-J9	10-1/2	12.84	1/2 Sq. Hole	6.96	2.41	3.10	1.87	.91	None	.10

Jacobs Keyless Portomatic Chucks



Designed for portable drill use and machine drilling where the keyless or self-tightening feature is required.

Ball bearing, rapid in action, powerful, yet easily released by a slight twist of the knurled sleeve. A tremendous grip which automatically tightens with increased load. Hardened and ground throughout. Perfect fit on all running parts. Furnished in all standard tapers and threads, and interchangeable on all present Jacobs equipped spindles.



Chuck Model	Capacity	Price Each	Mount	Screws Each	Jaws Per Set	Carriers Each	Collars Each	Balls & Washers Per Set
250	0-1/4	\$8.56	2 Short JT	\$2.14	\$1.87	\$1.87	\$.80	\$.43
250-1A	0-1/4	8.56	1JT	2.14	1.87	1.87	.80	.43
250B 3/8-24	3/8-24	8.56	3/8-24	2.14	1.87	1.87	.80	.43
250B 1/2-20	1/2-20	8.56	1/2-20	2.14	1.87	1.87	.80	.43
312	0-5/16	9.63	2 Short JT	2.41	2.14	2.14	.96	.53
312B 3/8-24	3/8-24	9.63	3/8-24	2.41	2.14	2.14	.96	.53
312B 1/2-20	1/2-20	9.63	1/2-20	2.41	2.14	2.14	.96	.53
375	0-3/8	10.70	2JT	2.67	2.41	2.41	1.07	.64
375B 1/2-20	1/2-20	10.70	1/2-20	2.67	2.41	2.41	1.07	.64
375B 3/8-16	3/8-16	10.70	3/8-16	2.67	2.41	2.41	1.07	.64
500	1/4-1/2	12.84	6JT	3.21	2.67	2.67	1.34	.64
500B 3/8-16	3/8-16	12.84	3/8-16	3.21	2.67	2.67	1.34	.64



Jacobs Commutator Kits

A complete unit designed especially to hold armature shafts rigidly and accurately during reconditioning. It contains a No. 75A Armature Driving Chuck and a No. 100 Center Rest Chuck—capacity 1/4-3/4 in.—mounted on head and tailstock respectively by means of No. 2 Morse Taper Arbors, which replace the centers. No. 1 Morse Taper Arbors are optional at the same price.

Jacobs Commutator Kit.....Complete \$24.18

Jacobs Spindle Nose Lathe Collet Chuck



The Jacobs Spindle Nose Collet Chuck featuring the Rubber-Flex Collet offers gripping power, accuracy, safety and economy never before achieved in collet chucking equipment. Rubber-Flex Collets provide two to four times the gripping power of the conventional split steel collets. The one piece forged steel body of the chuck offers the ultimate in accuracy. An ideal chuck for heavy duty cutting as well as for handling fragile and thin-walled pieces.

Model No.	Spindle Mount	Capacity	Price
91-C3	D1-3" Camlock	1/8-1 1/2	\$220.00
91-C4	D1-4" Camlock	1/8-1 1/2	220.00
91-C5	D1-5" Camlock	1/8-1 1/2	225.00
91-C6	D1-6" Camlock	1/8-1 1/2	225.00
91-T00	L00 Taper Key Drive	1/8-1 1/2	225.00
91-T0	L0 Taper Key Drive	1/8-1 1/2	245.00
91-T1	L1 Taper Key Drive	1/8-1 1/2	225.00
91-A6	American Standard A2-6"	1/8-1 1/2	225.00
91-A6	Threaded or Special Mount	1/8-1 1/2	225.00
91-F1	Threaded or Special Mount	1/8-1 1/2	220.00



The Rubber-Flex Collet

The most unusual feature of the Rubber-Flex Collet is that each collet has a full range of 1/8" and a set of eleven collets will chuck any diameter bar between 1/8" and 1 1/8". The collet jaws are always parallel to the work and their extra long bearing surfaces provide tremendous grip when closed on the bar.

Jacobs Rubber-Flex Collets,
J910 through J920 - Each \$13.00



PRINTED IN U.S.A.